



Apparatus for blow-moulding hollow bodies

Patent number: DE2316593
Publication date: 1974-10-24
Inventor: ROSE PETER
Applicant: HEIDENREICH & HARBECK GMBH
Classification:
- **International:** **B29C49/44**; B29C43/12; **B29C49/42**; B29C43/10;
(IPC1-7): B29C17/07
- **European:** B29C49/44
Application number: DE19732316593 19730403
Priority number(s): DE19732316593 19730403

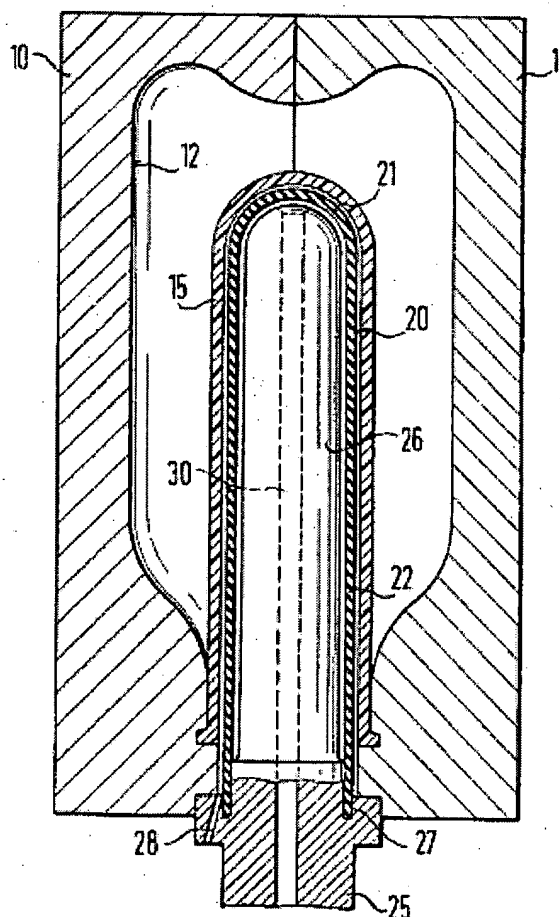
Also published as:

 US3918876 (A1)
 FR2224279 (A1)

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Abstract not available for DE2316593
Abstract of corresponding document: **US3918876**

Blow-moulding apparatus for blow-moulding elongated blanks of preheated thermoplastic material by; the use of a resilient bellows located upon a mandrel. The wall thickness of the bellows radially increases toward the bellows' closed end wherein initial expansion of the bellows and parison is in an elongated direction prior to significant radial expansion, and the interior of the parison is vented to insure complete contact between the bellows and parison.



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Int. Cl.: B 29 c, 17/07

BUNDESREPUBLIK DEUTSCHLAND

DEUTSCHES PATENTAMT



52

Deutsche Kl.: 39 a2, 17/07

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Offenlegungsschrift 2 316 593

Aktenzeichen: P 23 16 593.7-16

Anmeldetag: 3. April 1973

Offenlegungstag: 24. Oktober 1974

Ausstellungspriorität: —

30

Unionspriorität

32

Datum: —

33

Land: —

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Aktenzeichen: —

54

Bezeichnung: Vorrichtung zum Blasformen von Hohlkörpern

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Zusatz zu: —

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Ausscheidung aus: —

71

Anmelder: Heidenreich & Harbeck Zweigniederlassung der Gildemeister AG,
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Vertreter gem. §16 PatG: —

72

Als Erfinder benannt: Rose, Peter, 2359 Henstedt-Ulzburg

Prüfungsantrag gemäß § 28 b PatG ist gestellt

DT 2316593

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Family list**6** family members for:**DE2316593**

Derived from 3 applications.

- 1 Apparatus for blow-moulding hollow bodies**
Publication info: **DE2316593 A1** - 1974-10-24
DE2316593 B2 - 1977-08-18
DE2316593 C3 - 1978-06-01
- 2 Apparatus for blow-moulding hollow bodies**
Publication info: **FR2224279 A1** - 1974-10-31
FR2224279 B1 - 1978-03-24
- 3 Apparatus for blow-moulding hollow bodies**
Publication info: **US3918876 A** - 1975-11-11

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United States Patent [19]

Rose

[11] 3,918,876

[45] Nov. 11, 1975

[54] APPARATUS FOR BLOW-MOULDING
HOLLOW BODIES

3,816,046 6/1974 Farrell 425/389 X

[75] Inventor: Peter Rose, Henstedt-Ulzburg,
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Cantor

[22] Filed: Mar. 25, 1974

[21] Appl. No.: 454,664

[57]

ABSTRACT

Blow-moulding apparatus for blow-moulding elongated blanks of preheated thermoplastic material by the use of a resilient bellows located upon a mandrel. The wall thickness of the bellows radially increases toward the bellows' closed end wherein initial expansion of the bellows and parison is in an elongated direction prior to significant radial expansion, and the interior of the parison is vented to insure complete contact between the bellows and parison.

[30] Foreign Application Priority Data

Apr. 3, 1973 Germany 2316593

[52] U.S. Cl. 425/389; 425/390

[51] Int. Cl.² B29D 23/03

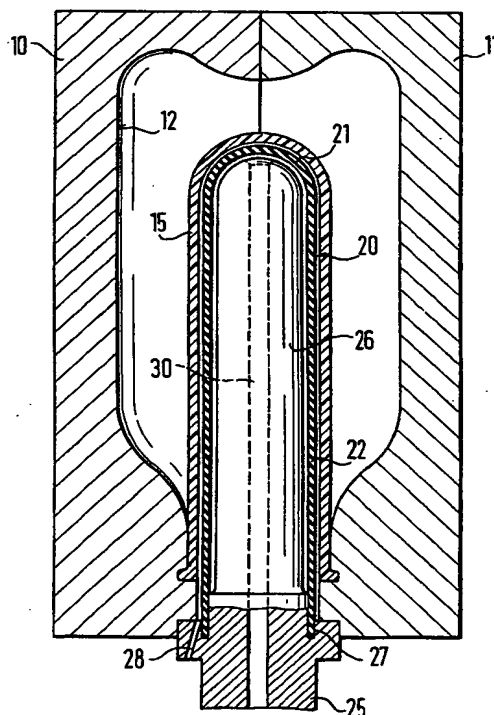
[58] Field of Search 425/389, 390, DIG. 14

[56] References Cited

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1 Claim, 1 Drawing Figure



PATENT SPECIFICATION

(11)

1 546 234

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(21) Application No. 12624/76 (22) Filed 29 March 1976

(44) Complete Specification published 23 May 1979

(51) INT. CL.³ B29C 17/07

(52) Index at acceptance

B5A 1R314C3 2A1 2A3 2A4C 2A4D 2E4C 2E4E 8B3 8C2
8D3 8H 8N3 T15E

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(19)



(54) IMPROVEMENTS IN OR RELATING TO BLOW MOULDING APPARATUS

(71) We, FARRELL PLASTIC MACHINERY CORPORATION, a corporation of the State of New Jersey, United States of America of 1 Cory Road, Morristown, New Jersey 07960, United States of America do hereby declare the invention, for which we pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

This invention relates to blow moulding apparatus.

Conventional injection blow moulding apparatus operates through a cycle beginning with the injection of a plastics material into an injection mould containing a core rod. A parison is formed around the core rod, and the injection mould then opens and permits the core rod to move to the next station of the blow moulding machine at which the next step of the moulding process is performed.

The second station is usually a blowing mould in which the parison is blown to the desired shape of a finished article; and when the blown article cools sufficiently, it is removed from the blowing mould and transferred to a stripper station. At the stripper station the blown article is removed from the core rod.

One of the limitations on the speed of a conventional cycle of such an injection blow moulding apparatus is the time required to cool the blown article sufficiently to remove it from the blowing mould prior to introduction to the stripper station. The present invention seeks to provide blow moulding apparatus, in the operation of which it is possible to cool the blown article more quickly than has previously been possible and thereby reduce time cycle of the apparatus and correspondingly increase the production of the blow moulding apparatus.

According to one aspect of this invention there is provided a blow moulding

apparatus including a core rod support, a core rod assembly comprising a core rod for supporting a parison to be blow moulded, means near one end of the core rod for connecting it with the core rod support, an elastic balloon that fits closely over the core rod when said balloon is deflated, and means for supplying fluid under pressure from the core rod to inflate the balloon and the parison thereof and including a shroud having a shape similar to the shape of the article to be blown from the parison but somewhat larger, and means to supply a flow of cushioning fluid through the shroud and into contact with the outside of the blown parison within the shroud, the shroud having a multitude of perforations opening through the surface thereof that confronts the blown parison inside the shroud and through which, in operation of the apparatus streams of the cushioning fluid flow into contact with the outside surface of the blown parison.

In a preferred embodiment of the invention, an elastic balloon is attached to a core rod assembly in position to hug the core rod when the balloon is deflated. When a parison is formed over the core rod, it is applied over the outside of the collapsed balloon and over a short length of the core rod assembly beyond the end of the balloon. This short length of the parison is the portion which forms the mouth or neck of the article to be blown and it is a portion of the parison which is not expanded in the blow mould.

The balloon has important advantages. One is that it permits the blown article to be cooled from the inside. Cooling fluid can be circulated through the inside of the balloon during a blowing operation and immediately after the completion of the blowing operation.

The core rod of a preferred embodiment of this invention is constructed so that